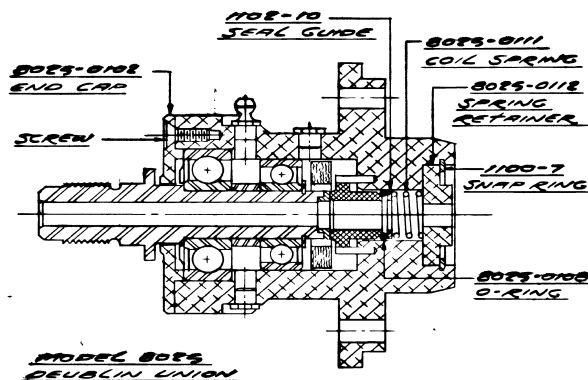
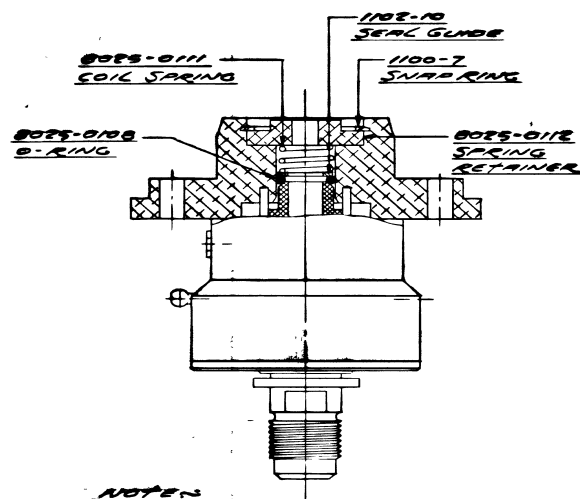


- 1 REMOVE SCREWS FROM END CAP WITH ALLEN WRENCH. REMOVE SNAP RING WITH #113 T-SQUARE PLIERS & REMOVE SPRING RETAINER. DISCARD COIL SPRING, SEAL GUIDE & O-RING.

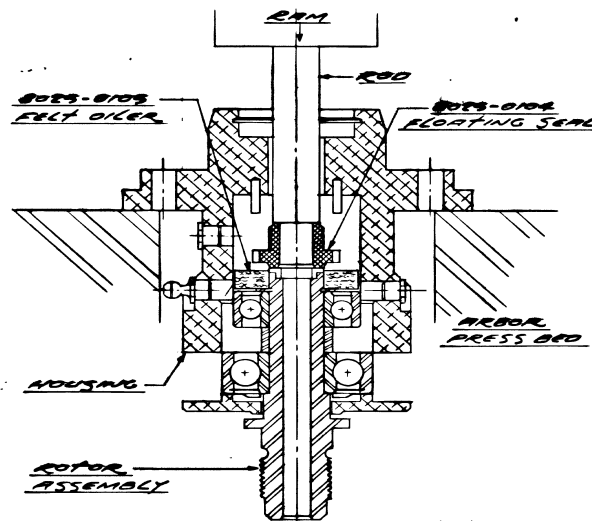


- 4 INSTALL O-RING, SEAL GUIDE & COIL SPRING AS SHOWN. REPLACE SPRING RETAINER & SECURE WITH SNAP RING.



NOTES
TO BE CERTAIN UNION DOES NOT LEAK AFTER ASSEMBLY, IT SHOULD BE AIR TESTED AT 150 PSI.

- 2 REMOVE ROTOR ASSEMBLY FROM HOUSING AS SHOWN



REBUILDING KIT PARTS LIST

ROTOR ASSEMBLY:

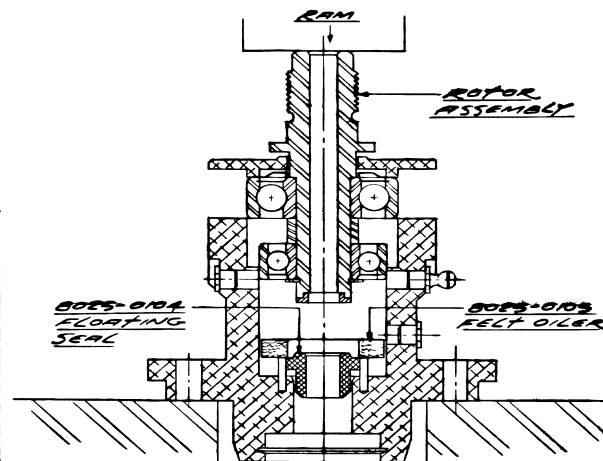
802S-0102 END CAP
802S-0107 NIOS SEAL
802S-0109 BALL BEARING
802S-0110 BALL BEARING
802S-0106 BEARING SPACER
1102-13 ROTOR SNAP RING
802S-0103 ROTOR, 3/4-16 NERN
802S-0104 FLOATING SEAL
802S-0105 FELT OILER
802S-0108 O-RING
1102-10 SEAL GUIDE
802S-0111 COIL SPRING
802S-0112 SPRING RETAINER
1100-7 SNAP RING

PRE-ASSEMBLED

TOOLS REQUIRED

- (TO BE FURNISHED BY CUSTOMER)
(1) METAL ROD, 9/16 DIA. X 8" LONG
(2) T-SQUARE PLIERS #113

- 3 CLEAN ROTOR SEAL FACE & FLOATING SEAL FACE. (SEAL FACES MUST BE FREE OF ALL DIRT & DUST)



REPLACE NEW FLOATING SEAL & FELT OILER. ON ENTIRE SEAL FACE WITH LIGHT VISCOSITY OIL. INSTALL NEW ROTOR ASSEMBLY INTO HOUSING & SECURE END CAP WITH THE (3) SCREWS.

NOTES

WHEN ASSEMBLING DEUBLIN UNIONS, CLEANLINESS IS AN IMPORTANT FACTOR. ALL PARTS MUST BE FREE OF DIRT AND CHIPS. THE PARTS MAY BE CLEANED WITH CHLOROTHENE, ALCOHOL, CARBON TETRACHLORIDE OR ANY GOOD CLEANING SOLVENT.

F		MATERIAL		SCALE	FULL	DEUBLIN COMPANY NORTHBROOK, ILLINOIS	
E				DRAWN	U.S.S.		
D				DATE		DIS-ASSEMBLY & ASSEMBLY PROCEDURE FOR MODEL 802S	
C				DATE			
B				DATE		TOLERANCES FRACTIONS ± .010 DECIMALS AS SPECIFIED	
A				DATE			
LET		REVISION	DATE	SIGN		PART NO DA-40	